

Work Order ID: 115331

March-25-14 3:18:44 PM

115331

Page 1

Item ID: D407-667-205TRN

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 3/25/14

Start Qty: 1.00

1

Required Date: 4/08/14

Req'd Qty: 1.00

1

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: 14-03-25

Tooling:

Date:

Run Start

NR1

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D407-667-245

Rev F

100

100

Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

1-Fill tube with sand & install plugs DT8531 on both ends as per Folio FA248

2-Turn first side as per Folio FA248

3-Blend transition lines only, **do not sand whole tube**:

FOLIO REV: AA

DWG REV: F

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

0.00

0.00

1 φ KE
14-03-28

110

110

QC

Quality Control

QC1: Inspect dimensions to dimension sheet

Memo

0.00

0.00

1 φ KE
14-03-26

Work Order ID 115331

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115331

Page 2

Item ID: D407-667-205TRN

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 3/25/14

Start Qty: 1.00

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Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

120

Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

1-Turn second side as per Folio FA248

2-Blend transition lines only, **do not sand whole tube**:

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

FOLIO REV: AADWG REV: E

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D407-667-245

0.00

0.00

1 / ϕ / KC
mm/L
14/03/28

130

130

QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

0.00

1 / ϕ /
mm/L
14/03/28

Work Order ID 115331

March-25-14 3:18:44 PM

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Page 3

Item ID: D407-667-205TRN

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 3/25/14

Start Qty: 1.00

1

Required Date: 4/08/14

Req'd Qty: 1.00

1

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

JW 14-04-07

145

0.00

145

Crosstubes

Memo

0.00

Crosstubes

Grind off circumferential machining marks longitudinally.

JB 14-04-08

150

0.00

150

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

1- PRESSURE WASH X-TUBE INSIDE AND OUT

2- ACID ETCH X-TUBE INSIDE AND OUT. USE RED SCOTCH BRITE

JB/BC 14-04-08

Work Order ID 115331

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Page 4

Item ID: D407-667-205TRN

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 3/25/14 Start Qty: 1.00

Required Date: 4/08/14 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

DAS
27
9-89***160***

QC

Memo

0.00

Quality Control

14/4/8

170

Packaging

0.00

170

Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack Location: Lg

B 14-04-08

180

QC21- Final Inspection - Work Order Release

0.00

DAS
27
9-89***180***

QC

Memo

0.00

Quality Control

14/4/9

14-04-09

Picklist Print

March-25-14 3:18:48 PM

Page 1
T

Work Order ID: 115331

115331

Parent Item: D407-667-205TRN

D407-667-205TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 Removed polish EC verified by: DD
IPP Rev:C 08-08-19 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6011-115		Manufactured		No		120	Each	25.0000	1	1			

D6011-115
Crosstube Material

**

Location

LG003

Loc Qty

25

Loc Code

67798

10

75639

15

LC 14-03-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

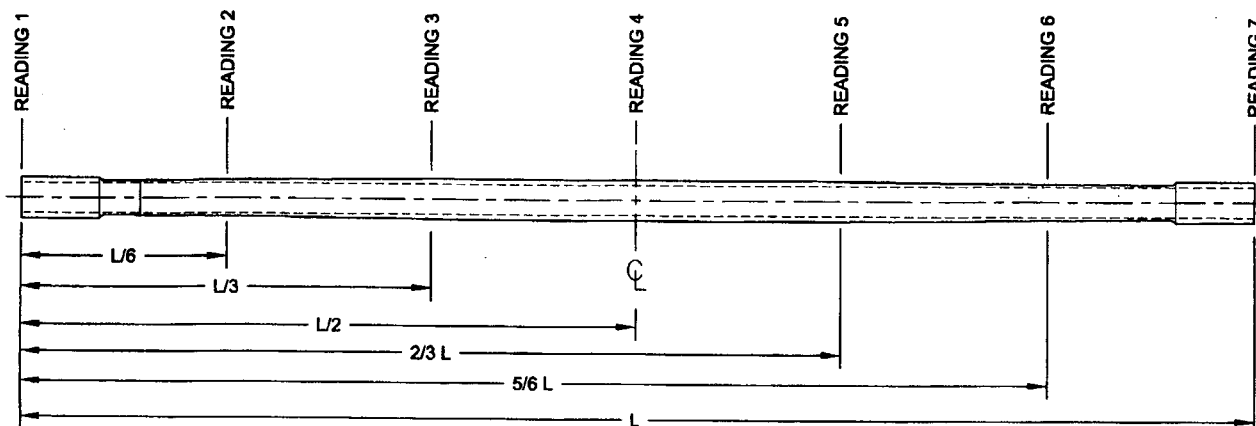
DART AEROSPACE LTD		Work Order:	15331
Description: Crosstube Assembly		Part Number:	D407-667-245
Inspection Dwg: D407-667-245 Rev: F		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.494	/		vern	CNC-08
	1.832	+0.005/-0.000	1.836	/		↓	
	1.838	+0.005/-0.000	1.841	/			
	1.892	+0.005/-0.000	1.895	/			
	2.052	+0.005/-0.000	2.056	/			
	2.206	+0.005/-0.000	2.209	/			
	2.521	+0.005/-0.000	2.524	/			
	2.633	+0.005/-0.000	2.635	/			
	4.10	+/-0.030	4.10	/		vern	CNC-08
	4.978	+/-0.030	4.980	/		↓	
	2.040	+0.000/-0.010	2.038	/			
	0.125	+/-0.010	.125	/			
	R0.063	+/-0.010	.063	/		R6	
	R0.500	+/-0.010	.500	/		"	
SIDE B	2.490	+0.005/-0.000	2.495	/		vern	CNC-08
	1.832	+0.005/-0.000	1.835	/		↓	
	1.838	+0.005/-0.000	1.841	/			
	1.892	+0.005/-0.000	1.895	/			
	2.052	+0.005/-0.000	2.056	/			
	2.206	+0.005/-0.000	2.208	/			
	2.521	+0.005/-0.000	2.525	/			
	2.633	+0.005/-0.000	2.635	/			
	4.10	+/-0.030	4.10	/		vern	CNC-08
	4.978	+/-0.030	4.980	/		↓	
	2.040	+0.000/-0.010	2.038	/			
	0.125	+/-0.010	.125	/			
	R0.063	+/-0.010	.063	/		R6	
	R0.500	+/-0.010	.500	/		"	
	112.91	+/-0.020	112.91	/		TAPE	LG-25

DART AEROSPACE LTD		Work Order:	115331
Description: Crosstube Assembly		Part Number:	D407-667-245
Inspection Dwg: D407-667-245 Rev: F		Page 2 of 2	

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation	TOLERANCE
	w1	w2	w3	w4	Δw (max-min)	
READING 1 L= 0"	.245	.240	.243	.245	.005	0.075"
READING 2 L= 17	.225	.224	.254	.258	.034	
READING 3 L= 36	.378	.391	.421	.419	.043	
READING 4 L= 56	.664	.666	.650	.654	.016	
READING 5 L= 36	.391	.401	.407	.406	.016	
READING 6 L= 17	.238	.247	.239	.232	.015	
READING 7 L= 6' 0"	.240	.244	.239	.249	.010	

Calibration Result

Actual Block Thickness: .100 - .750

Sitescan 250 Measured Thickness: .100 - .750

Measured by:	<i>[Signature]</i>
Date:	14/02/28

Audited by:	<i>[Signature]</i>
Date:	14-04-07

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-205)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	06.03.30	Tolerance revised for 4.978 dimension	KJ/JLM	
D	07.02.19	Dwg Rev updated	KJ/JLM	
E	09.05.20	Dwg Rev updated	KJ	
F	12.06.04	Wall thickness form added	KJ	<i>[Signature]</i>

Item	QTY -245	PART NUMBER	DESCRIPTION
1	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

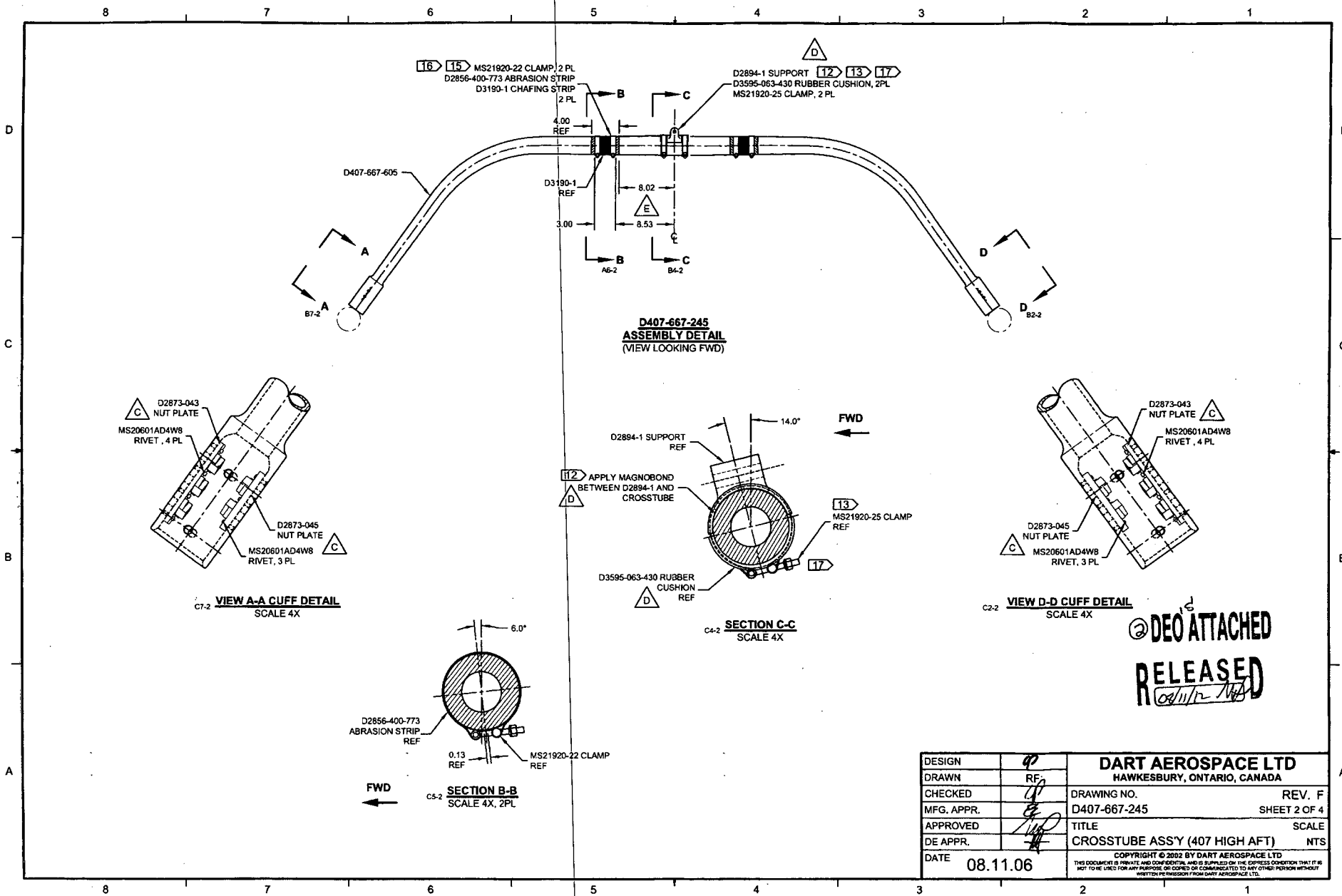
GENERAL NOTES:

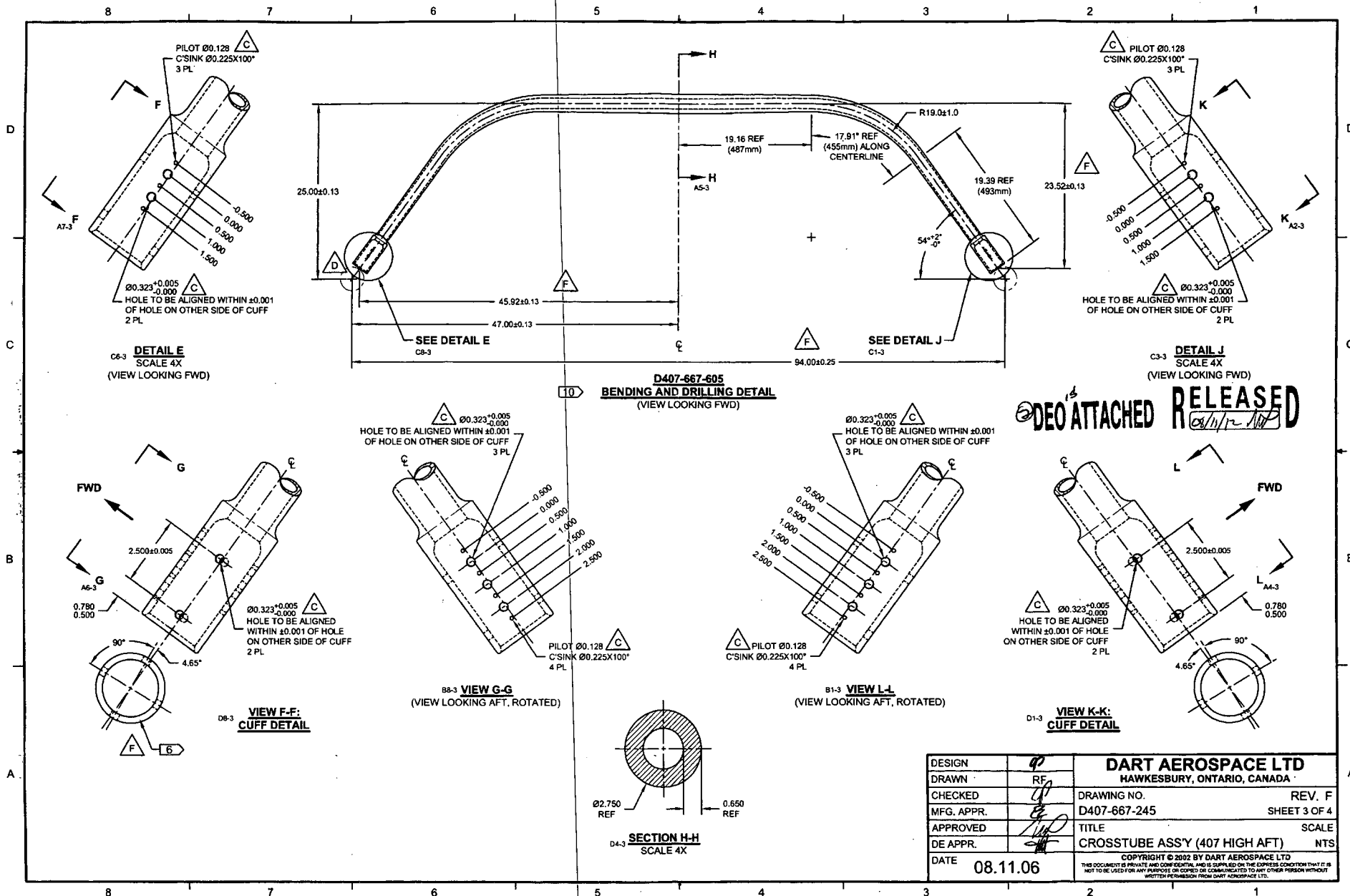
- 1) MATERIAL: MANUFACTURED FROM D6011-115
FINISHED LENGTH = 112.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 27.7 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND
6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO
PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE
SUPPORT.
NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS.
ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF
CROSSTUBE, PER QSI 035.
- 16) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE
OPPOSITE D2894-1 SUPPORT.
- 17) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

115331 MLS
14-03-25

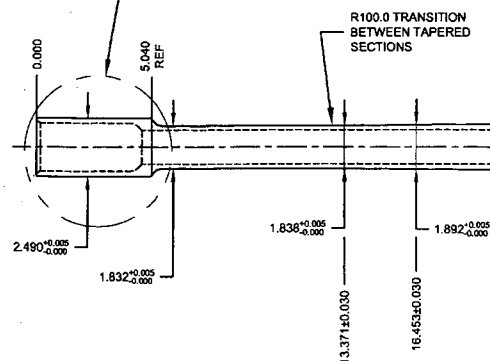
DEO ATTACHED
RELEASED
08/11/12

F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECR#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. F
CHECKED	RF	D407-667-245	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASSY (407 HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

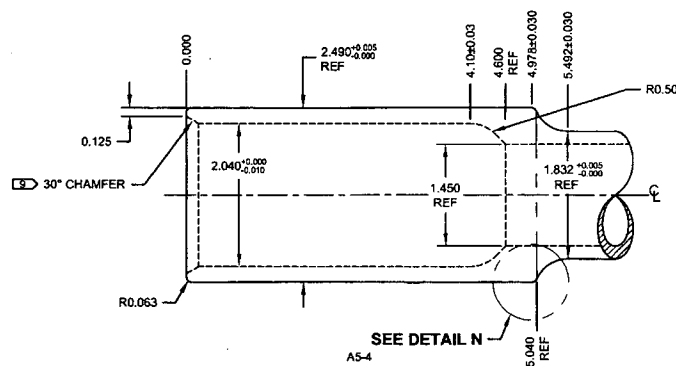




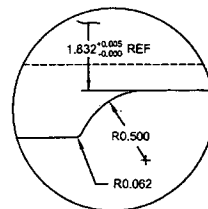
SEE DETAIL M
A7-4



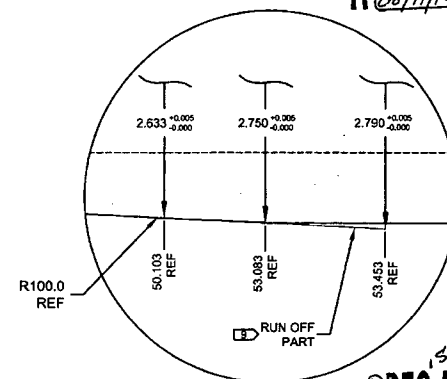
D407-667-245 MACHINING DETAIL



DETAIL M: CROSSTUBE CUFF
SCALE 3X



DETAIL N: CUFF TRANSITION
SCALE 2X



DETAIL P: TAPER RUN-OFF
NOT TO SCALE

RELEASED
08/11/12

DEO ATTACHED

DESIGN	40	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	40	DRAWING NO.	REV. F
MFG. APPR.	40	D407-667-245	SHEET 4 OF 4
APPROVED	40	TITLE	SCALE
DE APPR.	40	CROSSTUBE ASSY (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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DRAWING NO. D407-667-245	TITLE CROSSTUBE ASSY (407 HIGH AFT)	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D407-667-245-F-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 11.04.08	DATE 11.04.12	DATE 11.04.12	DATE 11.04.12	DATE 11.04.12			

PURPOSE:

REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890.

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

Item	Qty -245	Part Number	Description
3	0	D2856-400-773	ABRASION STRIP

WAS:

3	2	D2856-400-773	ABRASION STRIP
---	---	---------------	----------------

NOTES 2 AND 15, SHEET 1 ARE AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND
PAINT OUTSIDE PER DART QSI 005 4.2
REMOVE MASKING AND APPLY CLEAR COAT
- 15) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3190-1
CHAFING SHIELDS AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL
PROSEALED D3190-1 CHAFING SHIELDS ONTO CROSSTUBE BY APPLYING A THIN COAT
OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 REF GAP ON BOTTOM SIDE OF
CROSSTUBE PER QSI 035.

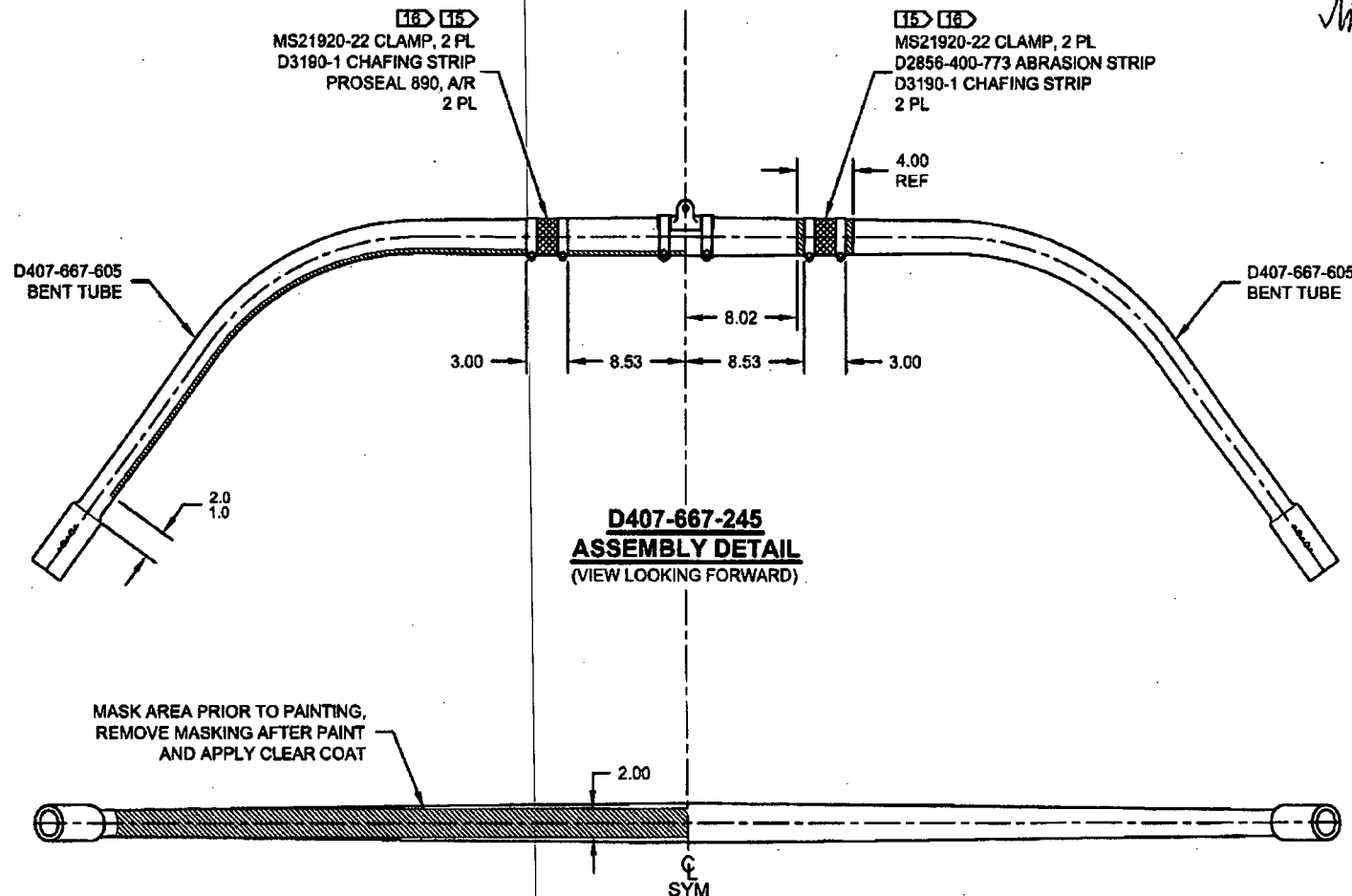
RELEASED
2011-04-18

DRAWING NO. D407-667-245	TITLE CROSSTUBE ASSY (407 HIGH AFT)	REV. F	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D407-667-245-F-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 11.04.08	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12		

IS:

WAS:

RELEASE
2011-04-18



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DRAWING NO. D407-667-245	TITLE CROSSTUBE ASS'Y (407 HIGH AFT)	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D407-667-245-F-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>BE</i>	APPROVED <i>MP</i>		DE APPR. <i>th</i>		
DATE 11.09.07	DATE 11.09.19	DATE 11.09.19	DATE 11.09.19		DATE 11.09.19		

PURPOSE:

REPLACE MAGNOBOND WITH 3M DP460 SCOTCH-WELD EPOXY ADHESIVE

CHANGE:

IS:

Item	Qty	Part Number	Description
	-245		
12	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD

WAS:

12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 17, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

WAS:

- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-09-29
MP